Lock All Fields

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LOC	DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	D2	ECR-13-005316	27MAR2013	XZ	LZ

Dimensioning and tolerancing per ASME Y14.5M-2009

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151346-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1385432
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR 1385432

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS:

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL

FINISH

DWN X. ZHAO
CHK L. ZHANG
APVD L. ZHAGN
PRODUCT SPEC
APPLICATION SPEC
WEIGHT

TE Connectivity

NAME SIDE FEED HDM APPLICATOR

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A3		C- 1385432	

SCALE | SHEET 1 OF 2 | REV D2

1470-19 (3/11)

Pro/ENGINEER DRAWING

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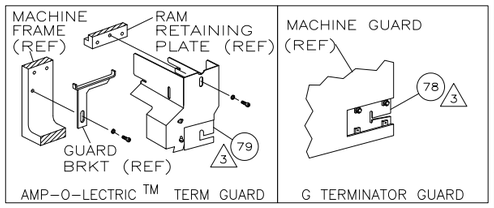
PART NUMBER	REV	FIRST USED
1385432–1	D	122500–1
1385432–2	D	565435–5
1385432–3	D	354500–1



TERMINAL NAME: 2.8MM SENSOR – FLAT TYPE RECEPTACLE 7

TERMINAL	SEAL PN
967543 (A)	828905–1
968088 (B)	828905–1
968857 (C)	828905–1

AMP TERMINAL AMP CRIMP SPECS

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.074 ±.002 [1.88 ±0.05mm]	2.50mm²
B	.068 ±.002 [1.73 ±0.05mm]	2.00mm²
C	.062 ±.002 [1.57 ±0.05mm]	1.50mm²
D	.059 ±.002 [1.51 ±0.05mm]	1.30mm²

CRIMP	SIZE	TYPE	RANGE
WIRE	.100 [2.54mm]	F	1.30 – 2.50mm²
INSUL	.165 [4.19mm]	0	.134 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.186–.208	114–18144–0 (A) 114–18148–1 (C) 114–18144–1 (B)	.472	408–8040	458637–1	L2674

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	D1	ECR–09–009221	4–2009	MY	GB

–1	LEADMAKER	MECH POST FEED
–2	BENCH MODEL K	MECH PRE FEED
–3	BENCH MODEL G	MECH PRE FEED

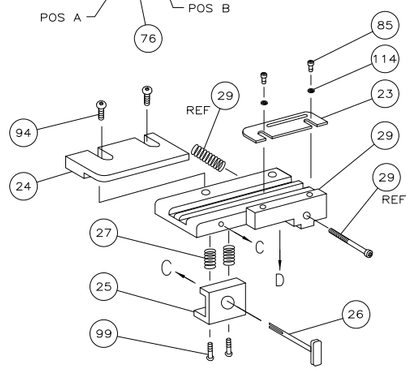
2	2	2	–	1–354779–3	PIN, WIRE DISC (.3055)D	129
2	2	2	–	354779–7	PIN, WIRE DISC (.3025)C	128
2	2	2	–	9–354778–3	PIN, WIRE DISC (.2960)B	127
2	2	2	–	8–354778–0	PIN, WIRE DISC (.2895)A	126
1	1	1	–	986950–1	WASHER, FLAT PRECISION	125
1	1	1	–	217238–1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	–	4088040	SF APPL INST 408–8040	123
						122
						121
REF	REF	REF	–	1–21030–1	PIN,DOWEL(Ø.187x.50)LEVER	120
REF	REF	REF	–	1–21030–6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
REF	REF	REF	–	21045–3	RING,RET "C"(Ø.187)FD FING PIN	118
1	1	1	–	21024–5	WASHER, LOCK(#10)ADJ BLOCK	117
REF	REF	REF	–	21024–5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	–	21024–5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	–	21024–2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	REF	REF	–	5–21028–1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
						112
4	4	4	–	21024–4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	–	21899–4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
						109
1	1	1	–	21018–5	NUT,HEX(NO.6)HOLDDOWN	108
REF	REF	REF	–	21068–5	NUT,HEX(6–32)FEED ADJ	107
						106
						105
						104
1	1	1	–	21009–2	SCR,SKT SET(1/4–20x.25 LW)RAM	103
2	2	2	–	21017–2	SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	–	6–23715–5	SCR,PAN HD(6–32x1.50)FEED ADJ	101
1	1	1	–	461264–1	PLATE, IDENTIFICATION	100
2	2	2	–	5–21006–6	SCR, SET(10–32x.75)DRAG	99
1	1	1	–	22733–8	SCR,BHC(8–32x.38 LW)ANVIL	98
REF	REF	REF	–	2–21002–9	SCR,BHC(10–32x.75)CAP	97
REF	REF	REF	–	2–22733–8	SCR,BHC(1/4–20x.62)HOUSING	96
REF	REF	REF	–	2–21002–7	SCR,BHC(10–32x.50)SG ADJ BLOCK	95
6	6	6	–	2–21002–2	SCR,BHC(8–32x.50)TERM H DWN	94
						93
1	1	1	–	1–21003–9	SCR,FHC(6–32x.38)DEP	92
1	1	1	–	1–21002–7	SCR,BHC(6–32x.38)CAM	91
						90
						89
						88
2	2	2	–	2–21000–7	SCR,SHC(8–32x.50)DEP–HOLD	87
1	1	1	–	2–22603–0	SCR,HEX HD(8–32x.31)FEED FINGER	86
2	2	2	–	1–21000–3	SCR,SHC(4–40x.25)FR ST GUIDE	85
1	1	1	–	2–21000–7	SCR,SHC(8–32x.50)STRIPPER	84
REF	REF	REF	–	3–21000–7	SCR,SHC(10–32x.75)FEED ROD GD	83
REF	REF	REF	–	3–21000–6	SCR,SHC(10–32x.62)FD ADJ BLK	82
1	1	1	–	7–21000–6	SCR,SHC(10–32x.31)SG ADJ BL	81
REF	REF	REF	–	3–21000–4	SCR,SHC(10–32x.38)PIVOT BLK	80
–	REF	–	–	455749–1	GUARD, WINDOW	79
REF	–	–	–	679532–1	INSERT, GUARD	78
						77
						76
						75
1	1	1	–	690603–1	SPRING, ASSIST	74
1	1	1	–	23030–1	SCR,SHC(6–32x.25 SL)INS DISC	73
REF	REF	REF	–	458109–1	WASHER, SPECIAL	72
REF	REF	REF	–	690517–1	SPACER	71
–3	–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO

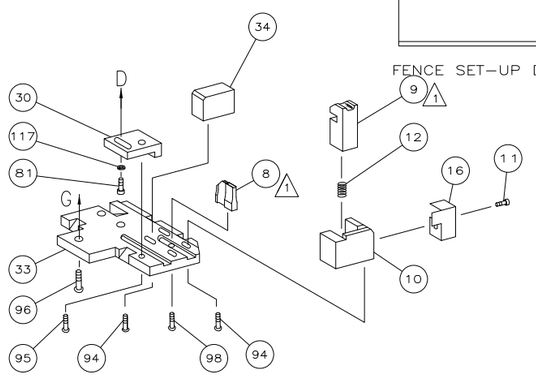
QTY REQD PER ASSY — PARTS LIST

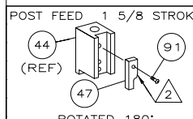
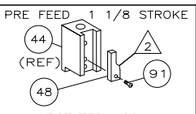
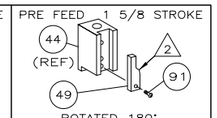
REF	REF	REF	–	22594–8	NUT,HEX(1/2–20)	70
REF	REF	REF	–	240628–1	PLATE, ADJUSTMENT	69
REF	REF	REF	–	240626–1	SHAFT, PIVOT	68
REF	REF	REF	–	240633–1	BUSHING	67
REF	REF	REF	–	455680–1	LEVER, INTERMEDIATE	66
REF	REF	REF	–	240629–1	BLOCK, PIVOT	65
REF	REF	REF	–	240632–2	SCREW, ADJ FEED ROD	64
REF	REF	REF	–	240659–3	PIN, CAM ROLLER	63
REF	REF	REF	–	240658–1	ROLLER, CAM	62
REF	REF	REF	–	454398–2	ROD, FEED	61
REF	REF	REF	–	454178–1	GUIDE, FEED ROD	60
REF	REF	REF	–	454220–1	CAP, RAM	59
REF	REF	REF	–	454485–1	HOUSING	58
						57
1	1	1	–	458537–2	PAWL, FEED	56
REF	REF	REF	–	240624–1	PIN, FEED FINGER	55
REF	REF	REF	–	691499–1	SPRING, FEED FINGER	54
REF	REF	REF	–	690541–1	HOLDER, FEED FINGER	53
REF	REF	REF	–	455679–2	LEVER, TERMINAL FEED ARM	52
1	1	1	–	811242–2	BUMPER, HOLDDOWN	51
1	1	1	–	690753–1	SPACER, TONKER	50
1	–	–	–	690602–6	CAM, PRE–FEED 1 5/8 ST	49
–	1	–	–	690602–5	CAM, PRE–FEED 1 1/8 ST	48
–	–	1	–	690501–4	CAM, POST–FEED 1 5/8 ST	47
1	1	1	–	459456–2	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	–	690191–1	PLUG, NYLON	45
1	1	1	–	455673–1	RAM	44
1	1	1	–	690125–1	WASHER, LAMINATED	43
1	1	1	–	690124–1	WASHER, RAM	42
1	1	1	–	7–21002–9	BOLT, CRIMPER(5/16x1.00)	41
1	1	1	–	23241–6	BALL, STEEL	40
1	1	1	–	690170–1	SPRING, COMPRESSION	39
1	1	1	–	690142–3	DISC, INSULATION	38
1	1	1	–	354777–1	WIRE DISC, PLASTIC	37
1	1	1	–	22480–5	WASHER, SPRING	36
1	1	1	–	690212–1	POST, RAM	35
1	1	1	–	690786–4	SUPPORT, TERMINAL	34
REF	REF	REF	–	455675–1	PLATE, BASE	33
						32
						31
REF	REF	REF	–	455689–1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	–	318756–1	STRIP GUIDE PLATE ASSY	29
1	1	1	–	1–455888–0	SPACER, FRONT SHEAR DEP	28
2	2	2	–	1–22284–0	SPRING, DRAG	27
1	1	1	–	690546–1	LEVER, DRAG RELEASE	26
1	1	1	–	240792–1	DRAG, TERMINAL	25
1	1	1	–	6–690504–9	GUIDE, STRIP (REAR)	24
1	1	1	–	690438–1	GUIDE, STRIP (FRONT)	23
–	–	1	–	690472–2	STRIPPER	22
REF	REF	REF	–	4–22284–9	SPRING, FEED RETURN	21
						20
1	1	–	–	691353–1	STRIPPER	19
						18
						17
1	1	1	–	318563–1	GUARD, CHIP, FRONT	16
						15
						14
						13
1	1	1	–	3–22280–3	SPRING, SHEAR	12
1	1	1	–	1–690461–9	STOP, SHEAR	11
1	1	1	–	1–690459–0	HOLDER, SHEAR (FRONT)	10
1	1	1	–	318707–1	SHEAR, FLOAT (FRONT)	9
1	1	1	–	2–662188–9	ANVIL	8
						7
						6
1	1	1	–	318701–1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	–	238011–4	SPACER, BLOCK CRIMPER	4
1	1	1	–	1424178–1	CRIMPER, INSULATION	3
1	1	1	–	1–455888–2	SPACER, CRIMPER	2
1	1	1	–	456407–5	CRIMPER, WIRE	1
–3	–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY — PARTS LIST

FENCE SET–UP DIM





POST FEED 1 5/8 STROKE	PRE FEED 1 1/8 STROKE	PRE FEED 1 5/8 STROKE
		
ROTATED 180° B	ROTATED 180° B	ROTATED 180° B
LEADMAKER	K TERMINATOR	G TERMINATOR

LEADMAKER & BENCH MACHINE

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
6. CUT TO LENGTH AT ASSY
7. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
8. APPLY TORQ–SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1–23419–5 LOC–TITE TO THREADS.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± – ; 1 PLC ± – ; 2 PLC ± .02 ; 3 PLC ± – ; 4 PLC ± – ; ANGLES ± –
MATERIAL –
FINISH –

DWN 04JUN02 C.REICHELDERFER
CHK –
APVD 04JUN02 T.ELBIN
PRODUCT SPEC – – –
APPLICATION SPEC –
WEIGHT –

Tyco Electronics Corporation, Harrisburg, PA 17105–3608

NAME SIDE FEED HDM APPLICATOR – –

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C–1385432	–

CUSTOMER DRAWING — SCALE – — SHEET 1 OF 1 — REV D1

4805 (1/08)

24APR2009 10:01am

Dimensioning and tolerancing per ASME Y14.5M-2009

Общество с ограниченной ответственностью «МосЧип» ИНН 7719860671 / КПП 771901001
Адрес: 105318, г.Москва, ул.Щербаковская д.3, офис 1107

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Нашей специализацией является поставка электронной компонентной базы двойного назначения, продукции таких производителей как XILINX, Intel (ex.ALTERA), Vicor, Microchip, Texas Instruments, Analog Devices, Mini-Circuits, Amphenol, Glenair.

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На всех этапах разработки и производства наши партнеры могут получить квалифицированную поддержку опытных инженеров.

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